

Date: Tuesday, 9/4/2007 11:30:15 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HEAT OUTLET DEFLECTOR
Job Number	: 34415		
Estimate Number	: 12154		
P.O. Number	: N/A	Part Number	: D34721
This Issue	: 9/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3472 REV.A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32134	Drawing Revision	: A
	Type : PURCHASED PARTS	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 10/4/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	6 Um: Each
Comment	: est rev. A 06.02.02 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.0573 sf(s)/Unit Total : 0.3440 sf(s)
 2024-T3 .040 sheet
 Batch: M103321

SAD 07/09/09

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 Cut as per Dwg D3472
 Dwg Rev: A
 Prog Rev: A

SAD 07/09/09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/09/09

6

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Er 07/09/10

counts

(26)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- Deburr

SAD 07/09/11 (6)

2-Bend as per dwg D3472

SAD 07/09/25

3- Buff-out any marks due to bending

FF 07/09/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 01/05/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:30:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAT OUTLET DEFLECTOR

Job Number: 34415

Part Number: D34721

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/09/25 (6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 07/09/25 6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 07-09-25 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 07/09/25 6

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/26

Job Completion



07/09/26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr		Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

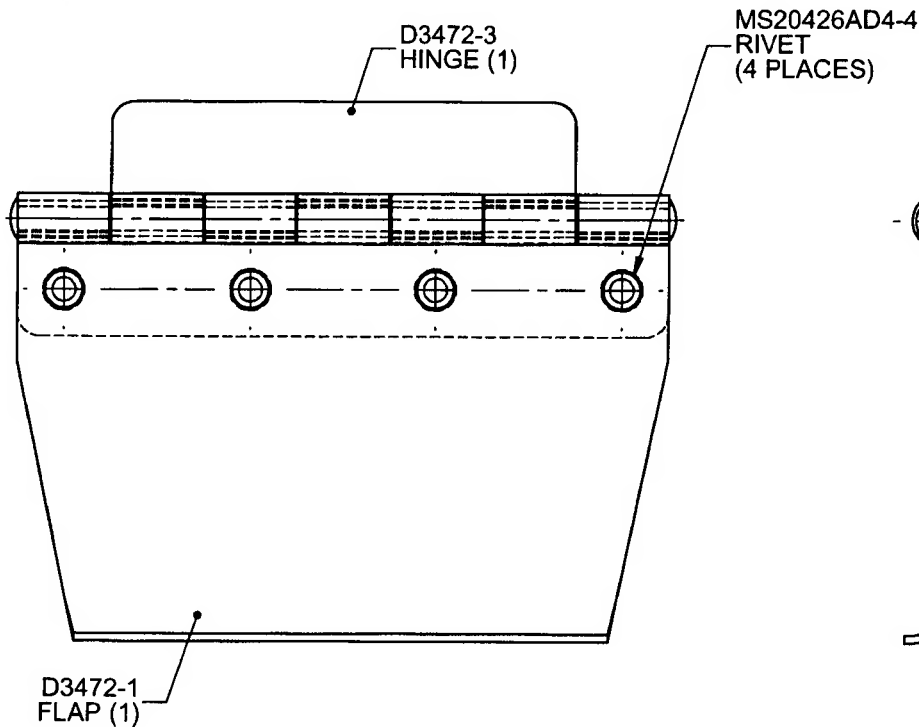
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date		Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3472	REV. A SHEET 1 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR SCALE 1:1	
A	06.01.17	NEW ISSUE	

06.04.03 *[Signature]***D3472-041 CABIN HEAT OUTLET DEFLECTOR**

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NO. *34415*

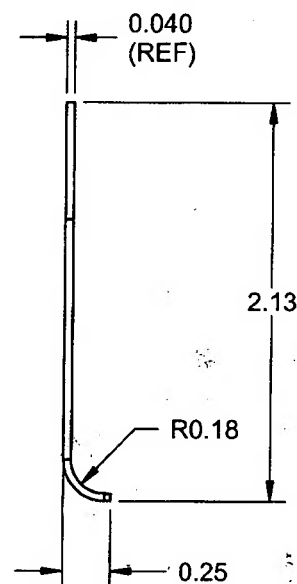
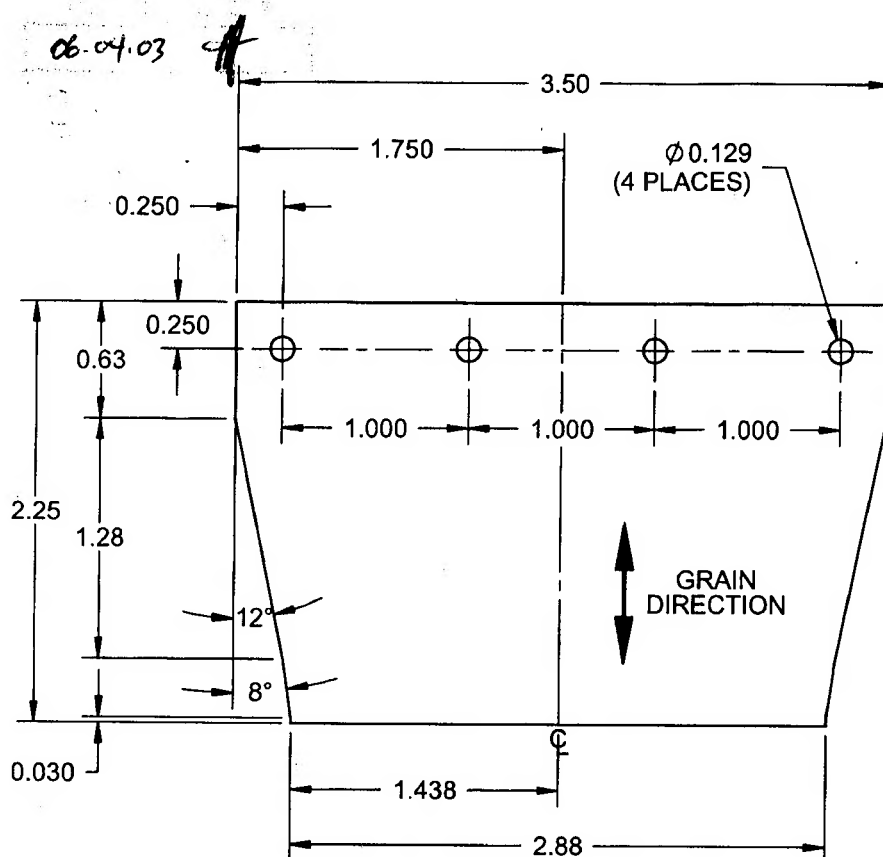
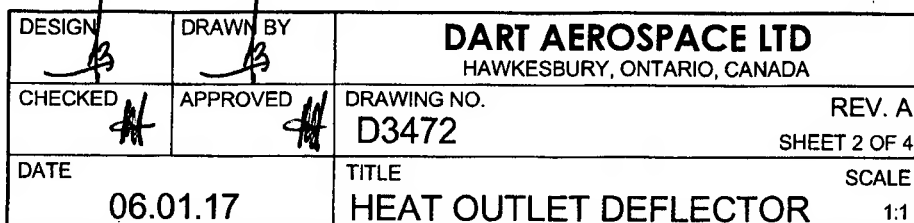
NOTES:

- 1) IDENTIFY WITH DART P/N D3472-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3472-041	CABIN HEAT OUTLET DEFLECTOR
1	D3472-1	FLAP
1	D3472-3	HINGE
4	MS20426AD4-4	RIVET

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D3472-1F FLAP FLAT PATTERN

D3472-1 FLAP BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 3445

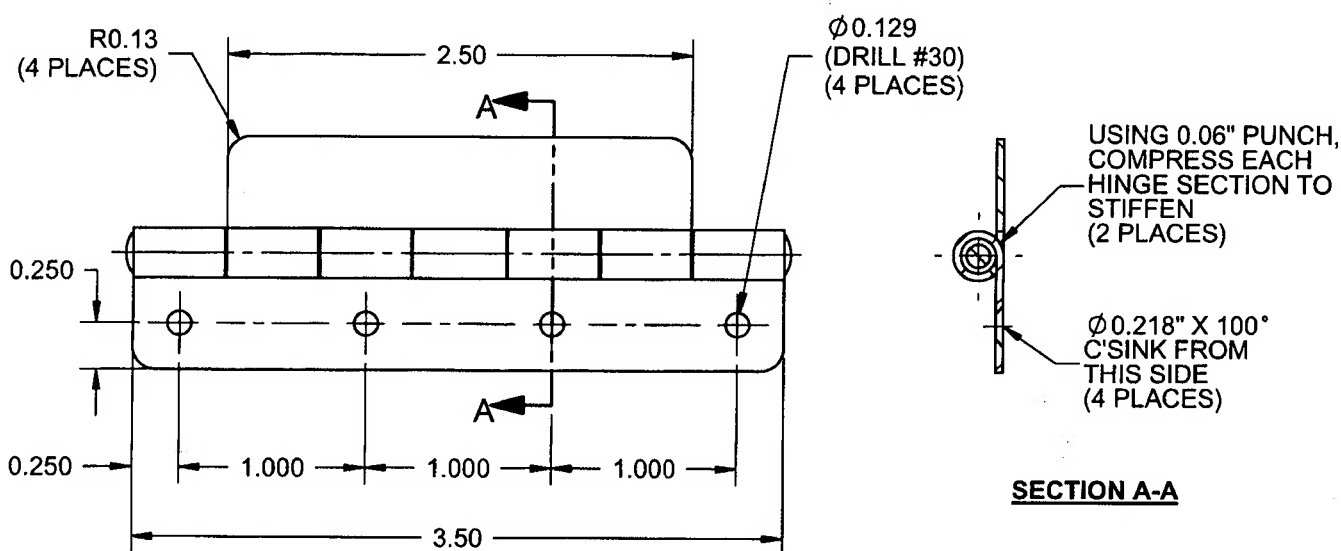
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3472	REV. A SHEET 3 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1

06.04.07 #

**D3472-3 HINGE****NOTES:**

- 1) MAKE FROM MS20257-3 HINGE, MODIFIED AS SHOWN
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

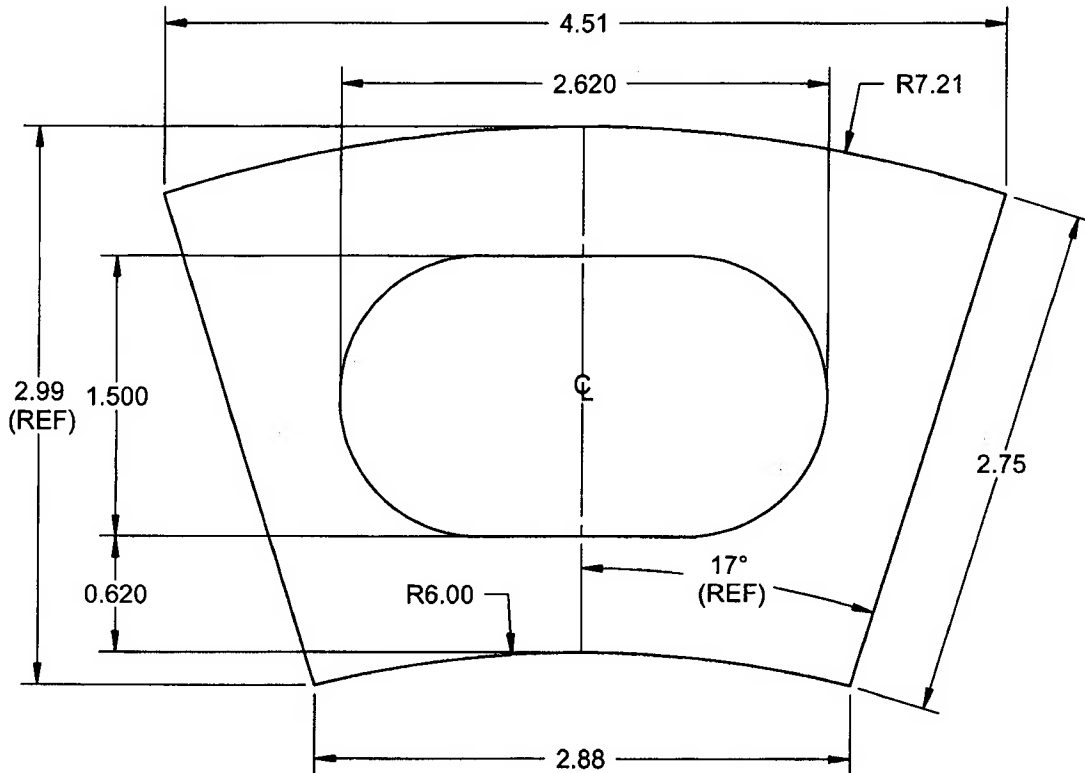
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3472	REV. A SHEET 4 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1

06.04.03 *[Signature]***D3472-5 FLAT DOUBLER****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) IDENTIFY WITH DART P/N D3472-5 USING
FINE POINT PERMANENT INK MARKER
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD	Work Order:	34415
Description: Heat outlet Deflector	Part Number:	D34721
Inspection Dwg: D34721 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/> First Article	<input type="checkbox"/> Prototype
<p>1. Introduction</p> <p>2. Materials and Methods</p> <p>3. Results</p> <p>4. Discussion</p> <p>5. Conclusion</p>	<p>1. Introduction</p> <p>2. Materials and Methods</p> <p>3. Results</p> <p>4. Discussion</p> <p>5. Conclusion</p>

[illegible]

Measured by:	SAD	Audited by:	En	Prototype Approval:	
Date:	02/09/09	Date:	02/09/10	Date:	2/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	